

Date: Monday, 7/30/2007 1:54:15 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	33801		
Estimate Number	12782		
P.O. Number	:	Part Number	D35643
This Issue	7/30/2007	Drawing Number	D3564 REV C
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	C
Previous Run	33244	Material	:
Written By	:	Due Date	8/28/2007
Checked & Approved By	<u>HB 07-07-30</u>	Qty:	12
Comment	Est Rev A New Issue 07-03-08 ec	Um:	Each
	Est Rev B As per Rev C 07-07-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet
	Comment: Qty.: 0.9177 sf(s)/Unit Total : 11.0124 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>M304S16GA HB 07-07-31</u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ****(D3564-1F)**** Dwg Rev: <u>C</u> Prog Rev: <u>C</u> <u>HB 07-07-31</u>	(B) 07/08/01 (13)
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	<u>HB 07-07-31</u>	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	<u>HB 07-07-31</u>	(N3) 07/08/01
	Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155	FF 07-08-08
	Form Joggle as per Dwg D3564 on brake using Jig DT8157	FF 07-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:54:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33801

Part Number: D35643

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



EP
07/08/07 413



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M105138

FC

07/08/14

13

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/14

13

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/14

13

10.0 POWDER COATING POWDER COATING



M 104846

BR/M

07-08-15

13

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/08/15

13X

12.0 PACKAGING 1 PACKAGING RESOURCE #1



13X

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

FP 18

m-k 07/08/15

13.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-15

Job Completion



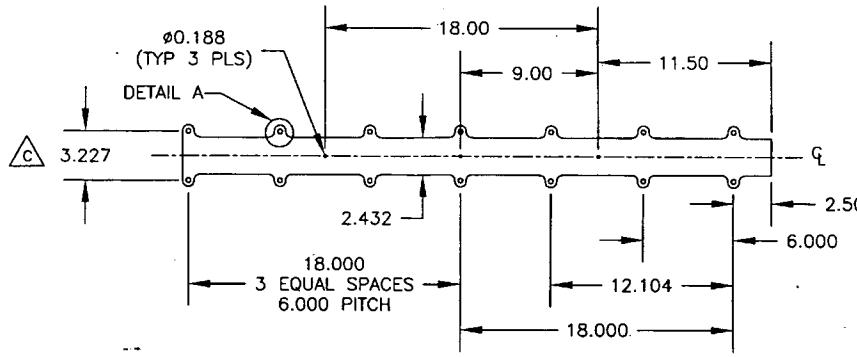
07-08-16

W/O:		WORK ORDER CHANGES					
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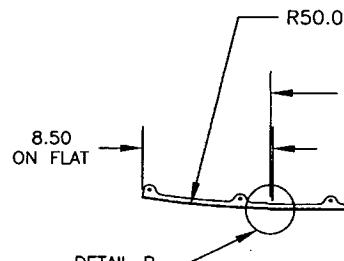
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

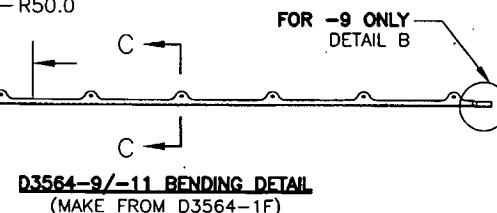
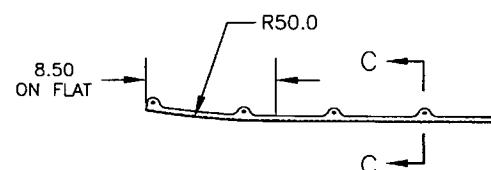
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

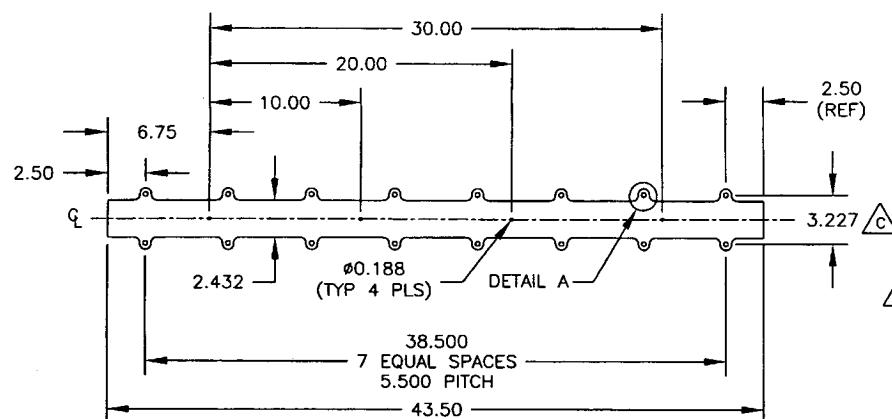
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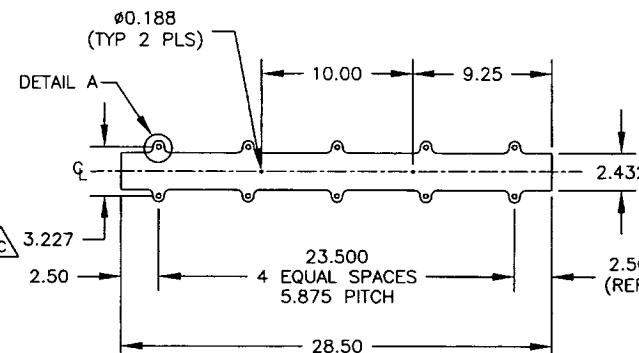
C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
<i>PS</i>	<i>PH</i>	DART AEROSPACE LTD. HAWTHORPE, ONTARIO, CANADA
CHECKED <i>PS</i>	APPROVED <i>PH</i>	DRAWING NO. D3564
DATE 07.04.17	SCALE	REV. C SHEET 1 OF 2
	TITLE WEARSHOE	1:8

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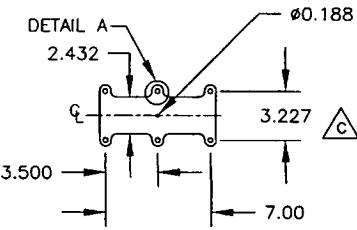
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07.06.28 *PH*



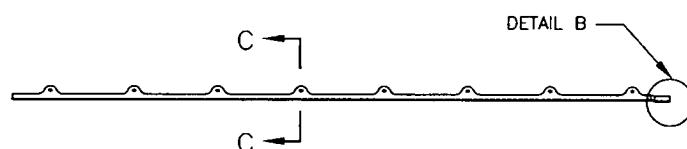
D3564-5F FLAT PATTERN



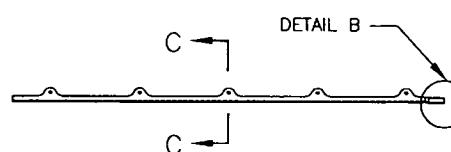
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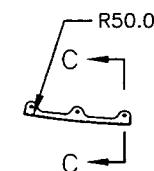
D3564-13F FLAT PATTERN



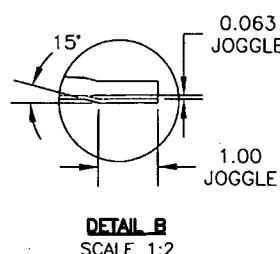
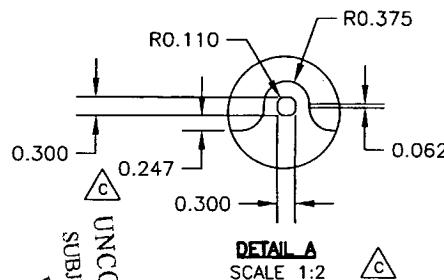
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



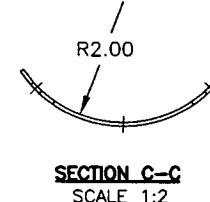
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.06.28/11

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWTHORPE, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO. D3564
DATE		07.04.17	TITLE WEARSHOE

REV. C
SHEET 2 OF 2
SCALE
1:8

DART AEROSPACE LTD	Work Order:	33801
Description: WEAR PAD	Part Number:	D 3564-3
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BB</u>	Audited by: <u>EP</u>	Prototype Approval: <u>NA</u>
Date: <u>07-07-31</u>	Date: <u>07/08/01</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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